

Work Order ID 74695

Wednesday, October 05, 2011 10:33:45 AM

Page 1

Item ID: D2844-3

Accept

Revision ID:

Item Name: Arm

Start Date: 10/5/2011 Start Qty: 12.00

Required Date: 10/28/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2844

Rev A

100

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form per Dwg D2844 using brake and bending Jig DT 8238-B 11 Deburr
at 20.900

110

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

120

0.00



Powdercoat

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M 119480

400°F

10:15

10:45

SB 11/12/02

12

Ac

11.11.04.

W

11.12.02

12

12x Ø m-f 11/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2844-3

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Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 10/5/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/12/12 5 (12)

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

5/11/12

(42)
7

150

Identify as per dwg & Stock Location: 265

0.00



Packaging

Memo

0.00

Packaging

Full 11/12 (12)

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/12/13
MF
11-12-13

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, October 05, 2011 10:33:42 AM

Page 1

Work Order ID: 74695

Parent Item: D2844-3

Parent Item Name: Arm



Start Date: 10/5/2011

Required Date: 10/28/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B: 00.11.01 Removed P/O for Powder Coat - in house process IEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	214.6323	1.765	22.29474			
304 RD Tube .500 x .035W													

Location

Loc Qty

Loc Code

MAT017

214.6322723

115535

2.33

116720

1.66068

117598

34.6415923

118702

176

M119160

22.29474

Ac 11.11.04

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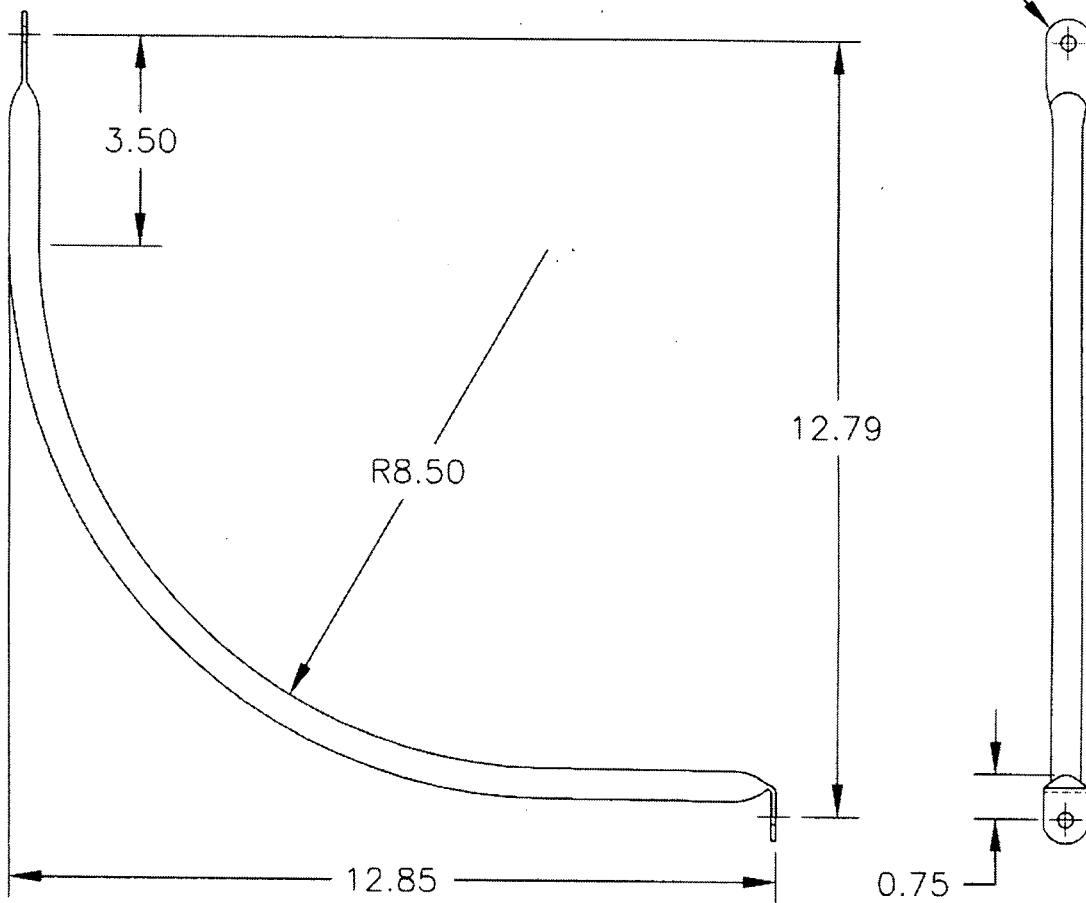


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>PAH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

Mo 74695



D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL

ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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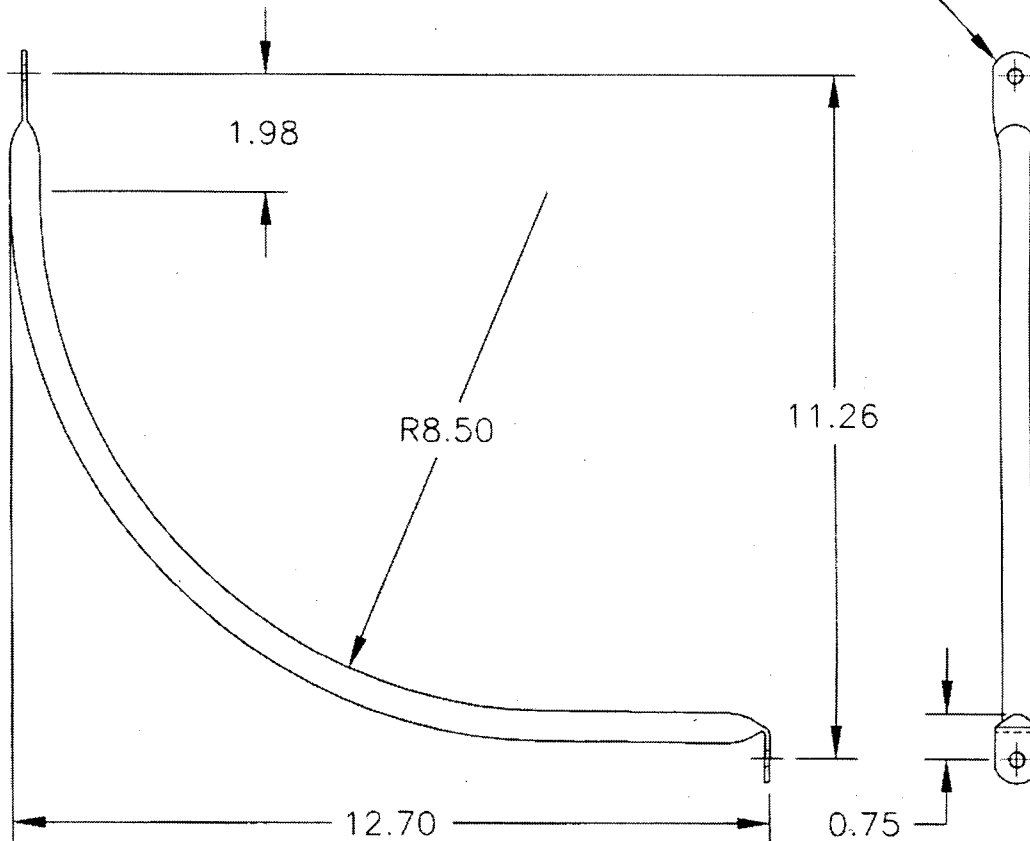
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED DHA	APPROVED [Signature]	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
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